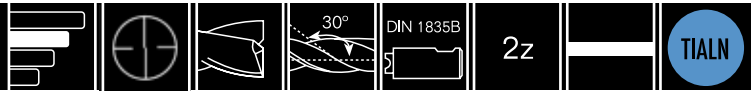


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HSSE DIN 844 N

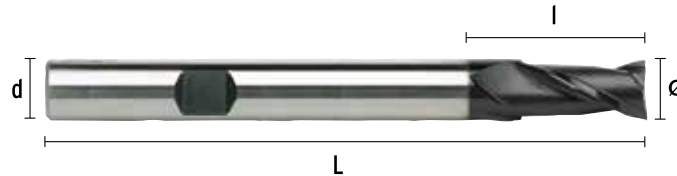
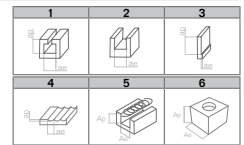


Vc (m/min)	P				M		K			N				S		H		
	<800 ● 48-80	<1.000 ● 40-45	<1.200 ○ 30-35	<1.400	<950 ○ 25-35	<1.200	<500 ● 55-60	<800 ● 30-40	<1.400 ○ 30-35	Al	Cu ○ 70-110	Mg/Zn	Plastic	Ni	Ti	50 HRC	55 HRC	60 HRC
K	1	1	0,7	0,7	0,7	1	1	1	0,7	1,3	1	1	1,3	0,7	0,7	0,7	0,7	0,7
fz	Ap	Ae	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø18	Ø20	Ø25	Ø32	Ø40
	1																	
	2	1,2xØ	1xØ		0,012	0,017	0,021	0,029	0,038	0,047	0,057	0,066	0,075	0,085	0,095	0,118	0,151	
	3																	
	4																	
	5																	
	6																	

$v_f(\text{mm/min}) = \text{rpm} \times Z \times f_z \times K$
 $\text{rpm} = (V_c \times 1000) / (\pi \times \phi)$

● Optima / Optimun ○ Alternativo / Alternative

Fresado
Fraisage
Milling
Fräsen



Ø mm	d mm	L mm	l mm	
4,00	6	63	11	1
5,00	6	68	13	1
6,00	6	68	13	1
7,00	10	80	16	1
8,00	10	88	19	1
9,00	10	88	19	1
10,00	10	95	22	1

Ø mm	d mm	L mm	l mm	
12,00	12	110	26	1
14,00	12	110	26	1
16,00	16	123	32	1
18,00	16	123	32	1
20,00	20	141	38	1
22,00	20	141	38	1
25,00	25	166	45	1

Bajo demanda / Sur commande / upon request



Aceros
Aciers
Steels
Stähle



Aceros Inox
Aciers Inox
Stainless Steels
Edelstahl



Fundición
Fonte
Cast Iron
Gusseisen



Metales no ferrosos
Métal non Ferreux
Non Ferrous metals
NE-Metalle



Titanio y Superalloys
Titanium et Superalloys
Titanium and Superalloys
Titan und Superlegierungen



Materiales Duros
Materiels Durs
Hard materials
Hartmaterialien